

Work Order ID 75044

75044

Page 1

October-17-11 10:32:30 AM

Item ID: D3417-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Washer
 Start Date: 17/10/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3417	Rev E

100 Hardinge CNC LATHE SMALL 0.00
100
 Doosan Memo 0.00
 Doosan Lathe 1-Turn as per Folio FA761
 Rev: 8
 Dwg D3417 Rev. 8
 2-Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75044

October-17-11 10:32:30 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 17/10/2011 **Start Qty:** 40.00

40

Cust Item ID:**Required Date: 27/10/2011 Req'd Qty: 40.00**

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan Code

Accept
Qty

Reject
Qty

Reject Number

Insp. Stamp

130

Identify as per dwg & Stock Location: C-53 0.00

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Sp 11-11-15

11/15

11-11-15
(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:32:35 AM

Page 1

Work Order ID: 75044

75044

Parent Item: D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased	No			110	f	30.6390	0.0296	1.246316			
MDFI RINR1 2500										**		40.0014	
DEL RIN ROUND BAR 1.25"													

Location

Loc Qty

Loc Code

MAT055

30.639

114586

6.639

119133

24

1.5 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

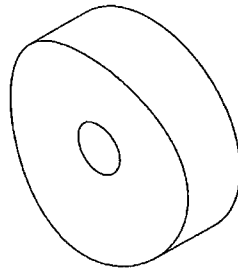
FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	
B	10.11.12	Dwg Rev updated	KJ	

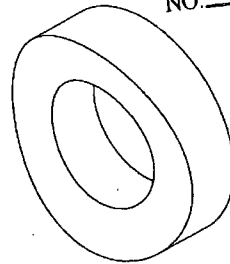
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 75044

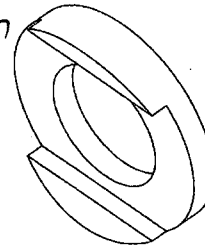
RII-10-1



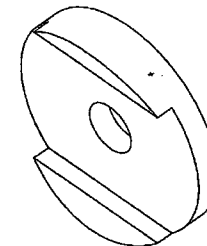
D3417-1 WASHER



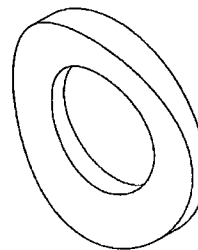
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



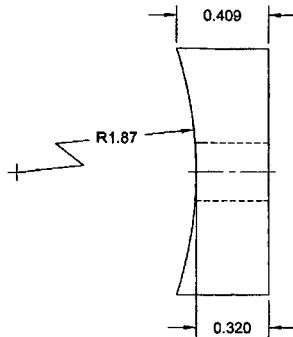
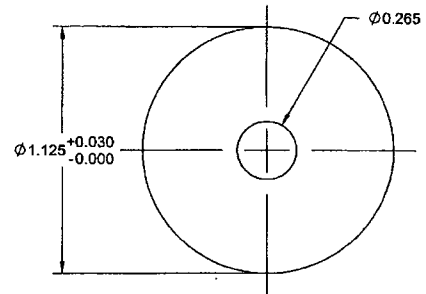
D3417-9 WASHER

RELEASED
2010-09-15
WJ

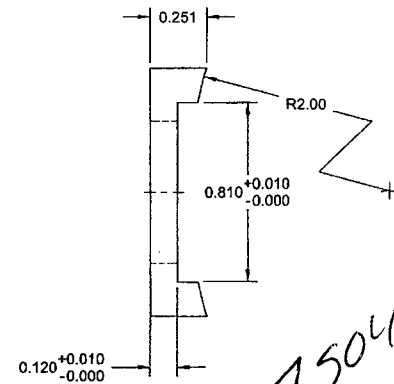
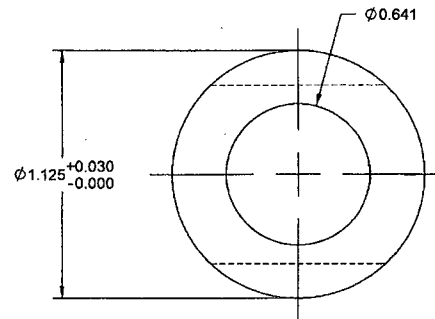
NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

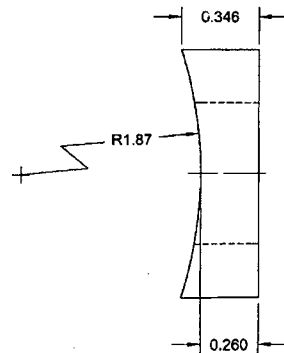
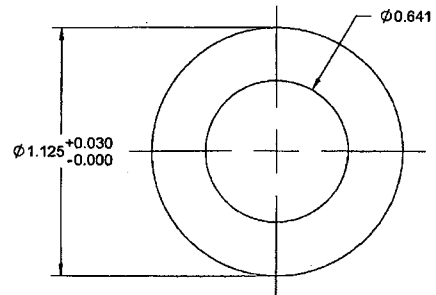
F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



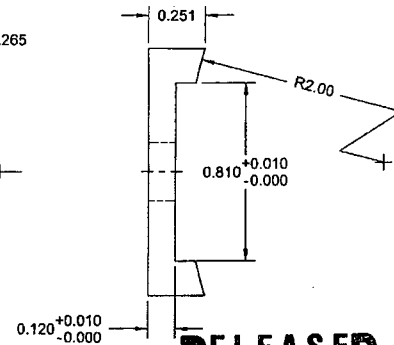
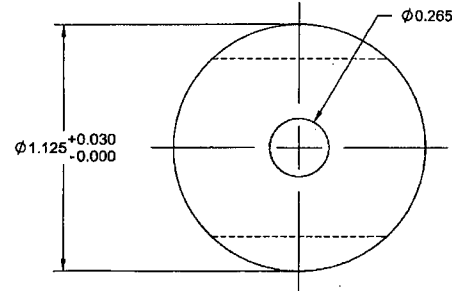
D3417-1 WASHER



D3417-5 WASHER



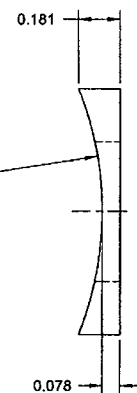
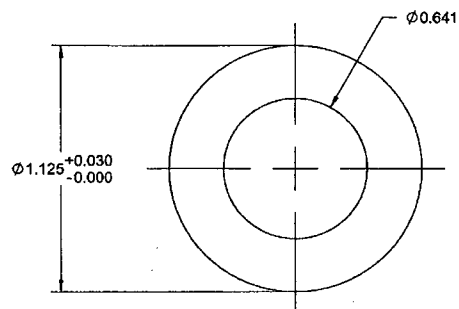
D3417-3 WASHER



D3417-7 WASHER

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2010-09-15

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MFG. APPR.		TITLE WASHER	SHEET 2 OF 3
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D3417-9 WASHER



750441

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2010-09-15

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